

Work Order ID 57334

Monday, April 05, 2010 2:50:05 PM

ASAP!!



Page 1

Item ID: D3915-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Light Lid Assembly, Long Basket Assembly

Start Date: 4/5/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 4/7/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: UMF

Date: 10-4-2005 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3915

A

100



Large Fab

Large Fab

Weld per dwg A/R Aluminum rod Batch: M112860 0.00
Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D3915
****DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE
A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID
FRAME****
2- weld hinge, label plate and Mounting plates as per dwg D3915

① PD 10.04.07

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds 0.00

Memo

0.00

② BE 10/04/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8 w/o 4/6/07

Memo

0.00



130



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

BR 10-4-7



ENSURE TO RINSE CAREFULLY ACID AND ALODINE

140



Large Fab

Large Fab

Weld per dwg A/R Aluminum rod Batch: 1112860

0.00

Memo

0.00

1- weld (4) corners

① PD 10.04.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

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Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



QC

Quality Control

150.1 QC9- Inspect visual per QSI004- Fusion Welds

0.00

150.2 *QC6 aspect to current step + Fit*

0.00

- 8104x10s

(H)

BE (N) 0 10/04/08 Pto ->

160



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M113170

Memo

- 1- touch up corner with alodine only
- 2- Plug holes prior to

0.00

=> HU 10/04/08

(X1) 0

1ST COAT:

START TIME: *8:00AM*

OVEN TEMPERATURE: *320°F*

FINISH TIME: *9:30AM*

***** 2nd coat if necessary *****

2ND COAT:

START TIME:



OVEN TEMPERATURE:

FINISH TIME:

/ n/a 5

W/O: 57334

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/04/02	#150	Perm. change AC 6 insert fit on Base.		10.04.12			 10/04/02

Part No: D3915-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BR 10-4-8

180

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

1- Install webbing as per dwg

2- Install placard and label as per dwg

4/5/10/04/08 (1)

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

5/10/04/10

(2)

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

Identify as per dwg & Stock Location: *G-9*

0.00



Packaging

Memo

w/ 57141

0.00

Packaging

JS 10/04/12

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/12 *10-4-12*

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Picklist Print

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Page 1

Work Order ID: 57334

Parent Item: D3915-041

Parent Item Name: Light Lid Assembly, Long Basket Assembly


Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Date: 4/5/2010

Required Date: 4/7/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2957  Mounting Plate		Manufactured	No			100	Each	25.0000	4.0000			

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

25

56660

1

57088

24

Manufactured

No

100

Each

8.0000

2.0000

PD 10.04.07

D3915-1



Rib

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

8

57089

8

BS7297

PD 10.04.06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 2

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Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Date: 4/5/2010

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Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4016-5  Hinge Half, Light Lid		Manufactured	No			100	Each	28.0000	3.0000 			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ENG	5	
56075	5	
Main Warehouse		
ST109	13	
57293	13	
Main Warehouse		
WA	10	
56951	10	

D4019-3



Rib

Manufactured No 100 Each 18.0000 3.0000



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
WA	18	
57090	12	
57296	6	

PD 10.04.07

PD 10.04.06

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Shop Packet Print

Page 2

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Required Date: 4/7/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4035-045 Lid Rib Assembly, Fwd (Light)		Manufactured	No			100	Each	4.0000	1.0000 			
<div> <div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>WA</div> <div>56972</div> </div> <div>Loc Qty</div> <div>4</div> <div>4</div> <div>Loc Code</div> <div>B57295</div> <div>PD 10.01.06</div>												
D4035-047 Lid Rib Assembly, Aft (Light)		Manufactured	No			100	Each	4.0000	1.0000 			
<div> <div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>WA</div> <div>56977</div> </div> <div>Loc Qty</div> <div>4</div> <div>4</div> <div>Loc Code</div> <div>B57294</div> <div>PD 10.01.06</div>												
D4056-1 Label Plate		Manufactured	No			100	Each	2.0000	1.0000 			
<div> <div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>WA</div> <div>56661</div> </div> <div>Loc Qty</div> <div>2</div> <div>2</div> <div>Loc Code</div> <div>B56933</div> <div>PD 10.01.07</div>												
D2728-1 Dart Logo label		Manufactured	No			180	Each	0.0000	1.0000 			

Monday, April 05, 2010 2:50:05 PM

Shop Packet Print

Page 3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10.04.08	110	USE MS20660 AD4WS INSTEAD OF AD4WS M 107939	<i>[Signature]</i>	10/04/08	34	<i>[Signature]</i> 10.09.08 QSP 142	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 4

Monday, April 05, 2010 2:50:05 PM

Work Order ID: 57334



Parent Item: D3915-041



Parent Item Name: Light Lid Assembly, Long Basket Assembly

Start Date: 4/5/2010

Required Date: 4/7/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4029-041 		Manufactured	No			180	Each	0.0000	1.0000			
Webbing (Long Basket)												
D4086-220 		Manufactured	No			180	Each	10.0000	1.0000			
Placard, Max Load												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST112

56979

MS20600-AD4W33

P10.04.08

Purchased

No



Blind Rivet

180

Each

450.0000

34.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST321

111477

NAS1149DN416J

Purchased

No



Washer

180

Each

0.0000

34.0000



QSI 17

AJ9603D4L

M14606

(20x)

M13910

(14x)

Monday, April 05, 2010 2:50:05 PM

Shop Packet Print

Page 4

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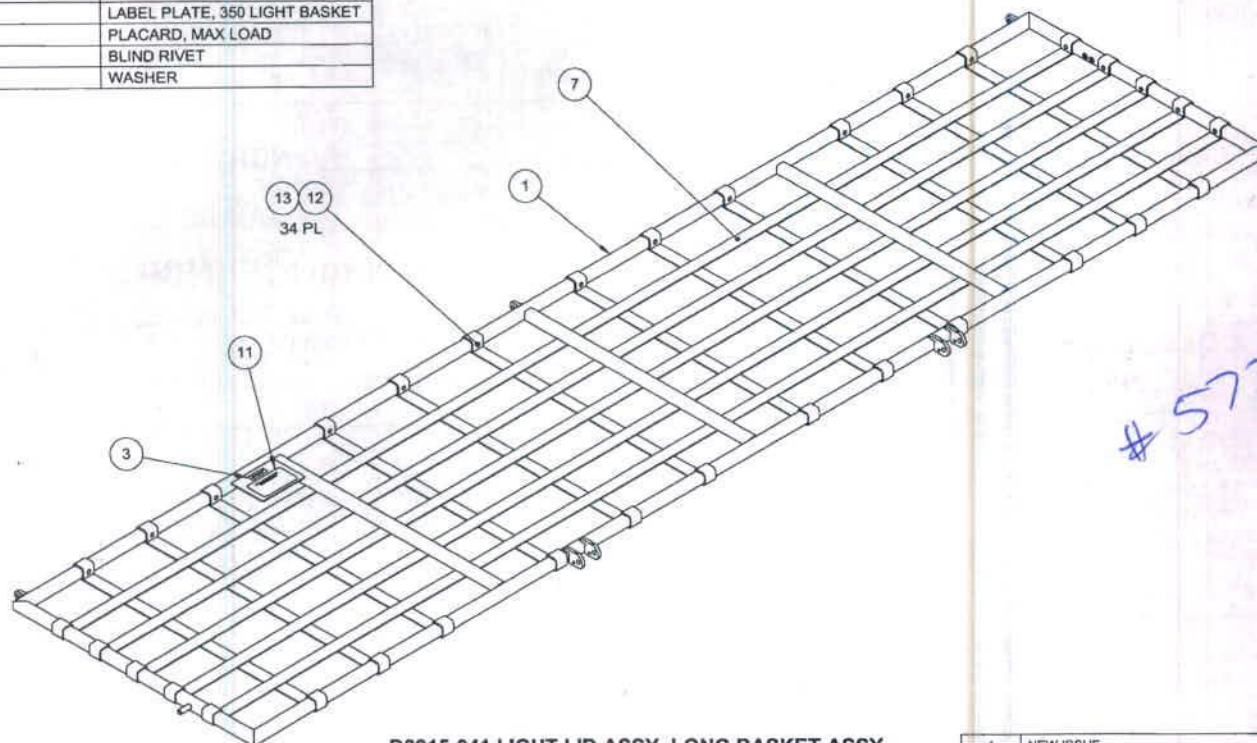
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ITEM	QTY -041	QTY -101	P/N	DESCRIPTION
	X		D3915-041	LIGHT LID ASSY, LONG BASKET
1	1	X	D3915-101	BASKET LID WELDMENT ASSY
2		2	D3915-1	RIB
3	1		D2728-1	DART LOGO LABEL
4		4	D2957	MOUNTING PLATE
5		3	D4016-5	HINGE HALF
6		3	D4019-3	RIB
7	1		D4029-041	WEBBING (LONG BASKET)
8		1	D4035-045	LID RIB ASSY, FWD
9		1	D4035-047	LID RIB ASSY, AFT
10		1	D4056-1	LABEL PLATE, 350 LIGHT BASKET
11	1		D4086-220	PLACARD, MAX LOAD
12	34		MS20600AD4W5	BLIND RIVET
13	34		NAS1149DN416J	WASHER



D3915-041 LIGHT LID ASSY, LONG BASKET ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.91 lbs

RELEASED
2010-03-22
ND

A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.16		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3915
REV. A
SHEET 1 OF 4

TITLE
LIGHT LID ASSY-LONG BASKET

SCALE
NTS

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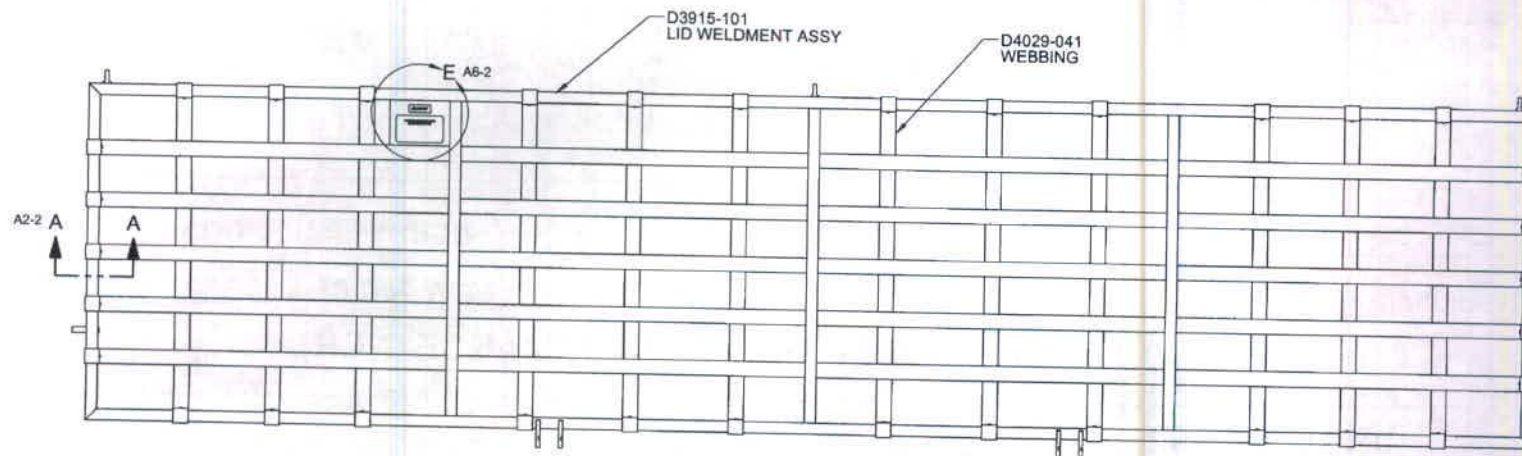
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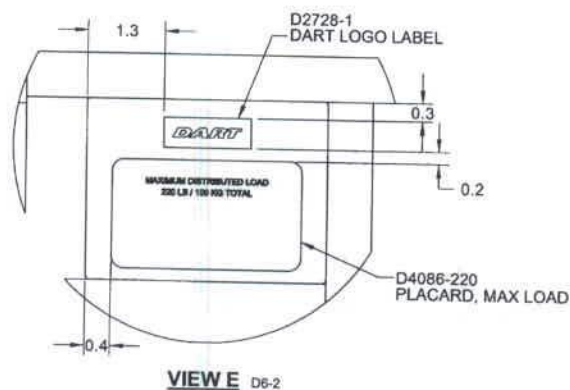
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NOTE: Date & initial all entries



D3915-041 LIGHT LID ASSY, LONG BASKET



SECTION A-A C8-2

RELEASED
2010-03-22

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	[Signature]	DRAWING NO.	REV. A
MFG. APPR.	[Signature]	D3915	SHEET 2 OF 4
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	LIGHT LID ASSY-LONG BASKET	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

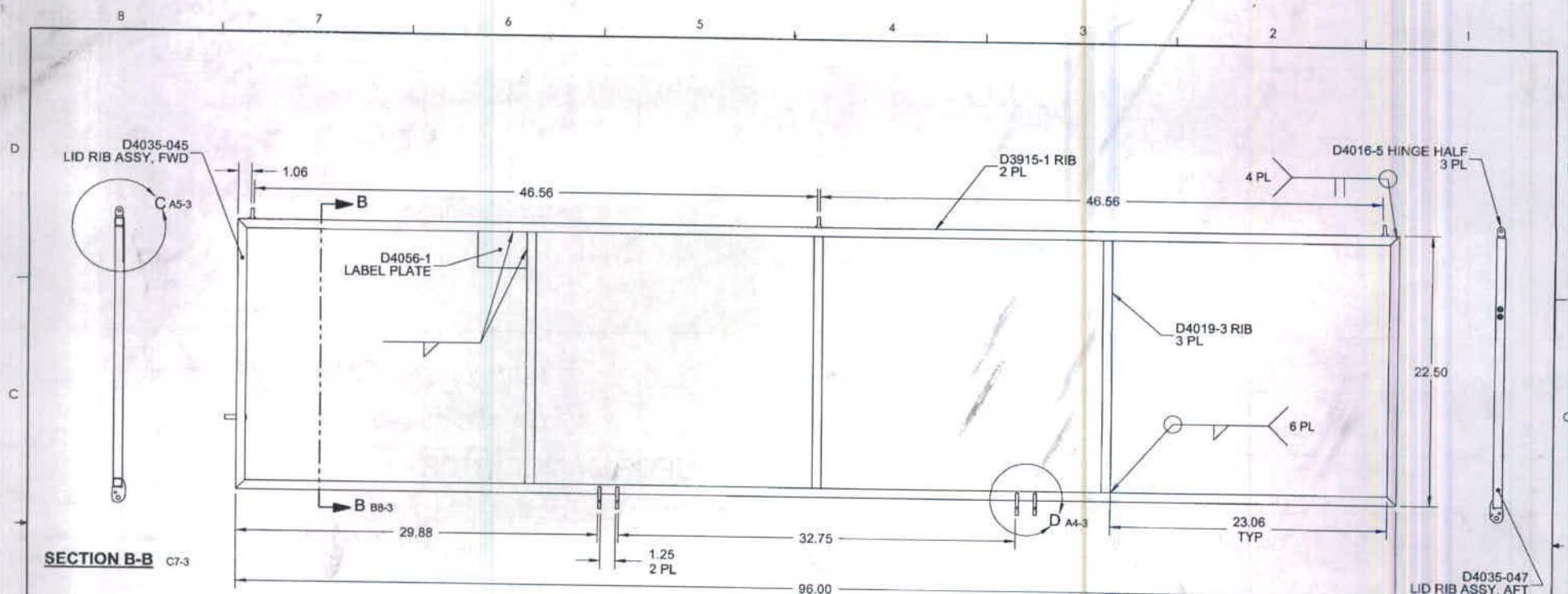
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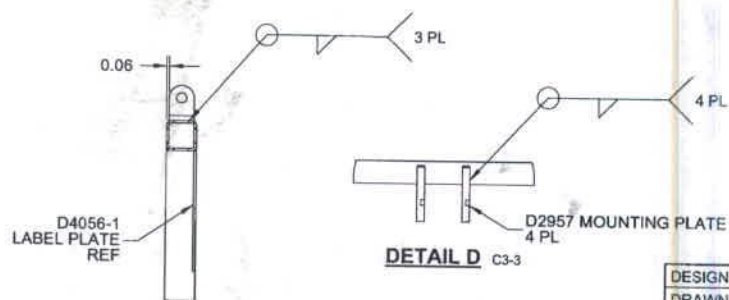
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D3915-101 BASKET LID WELDMENT ASSY ASSY



- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 4.81 lbs
 - 8) WELD PER DART QSI 004

DESIGN	A/S	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JA	DRAWING NO.	REV. A
MFG. APPR.	JA	D3915	SHEET 3 OF 4
APPROVED	JA	TITLE	SCALE
DE APPR.	JA	LIGHT LID ASSY-LONG BASKETNTS	
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

RELEASED
2010-03-22

#57334

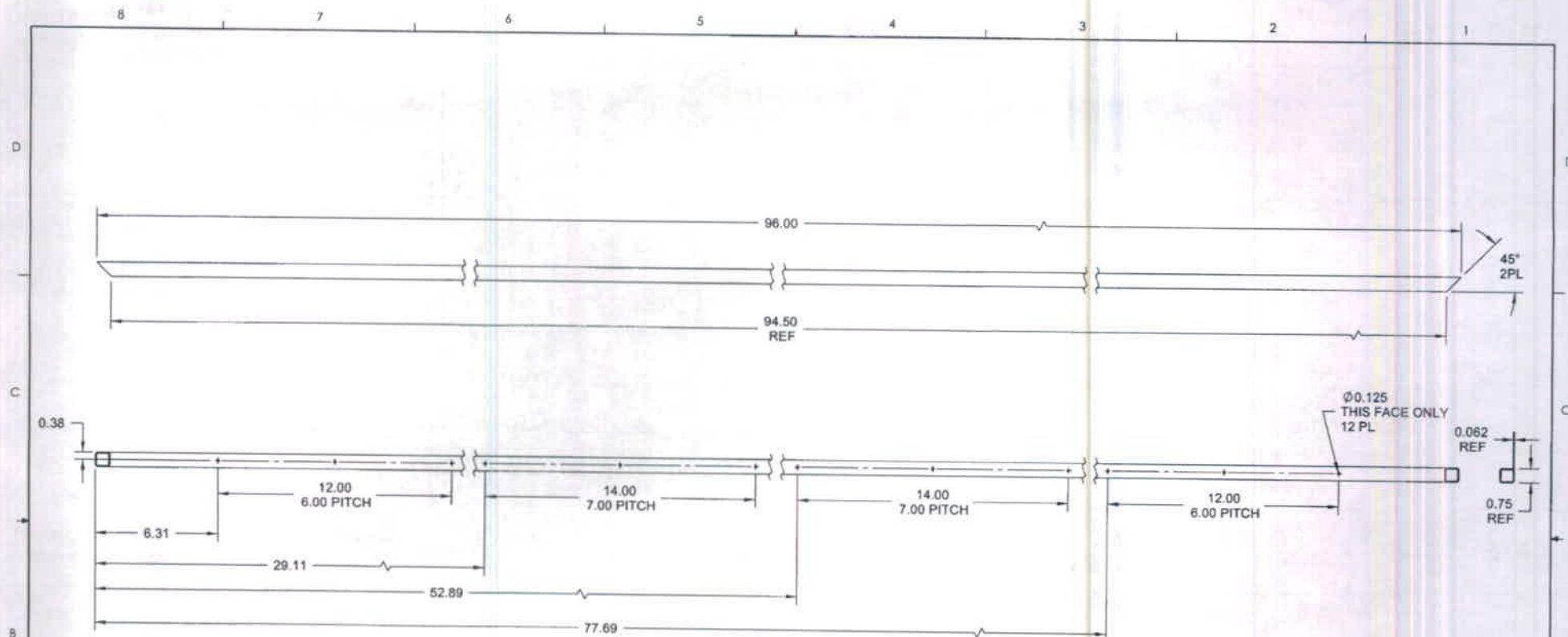
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D3915-1 RIB

#57334

RELEASED
2010-03-22

- NOTES:**
 1) MATERIAL: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING
 PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 REF DART SPEC. M6061T6TS0.750W.062
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 1.49 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3915	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LIGHT LID ASSY-LONG BASKETNTS	
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries